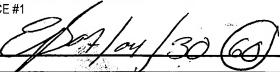
Dart Aerospace Ltd. Thursday, 4/12/2007 8:46:31 AM Kim Johnston User: **Process Sheet Drawing Name** : LUG . Customer : CU-DAR001 Dart Helicopters Services Job Number : 31737 : 10008 **Estimate Number** Part Number : D2591 P.O. Number MIA · D2591 REV D This Issue : 4/12/2007 S.O. No. : 1) A **Drawing Number** : NC : N/A Prsht Rev. Project Number : NIA Type : MACHINED PARTS : D First Issue **Drawing Revision** : 31231 · JA Material Previous Run : 5/5/2007 Qty: 60 Um: Each **Due Date** Written By Checked & Approved By Removed from 9 Digit 05-10-25 Comment : Est Rev:I **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: ASTM A21 Steel .75"x2.5" 1.0 M1010B0750X02500 Comment: Qty.: 0.2340 f(s)/Unit Total: 14.0400 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: M103069 x 19 parts BAND SAW 2.0 Comment: BAND SAW Cut blanks: 2.700" long HAAS1 HAAS CNC VERTICAL MACHINING #1 3.0 Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591 2-Deburr if required Comment: INSPECT PARTS AS THEY COME OFF MACHINE 5.0 QC8 Comment: SECOND 6.0 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:____



60

Dart	Aero	space	Ltd

									
W/O:		4,	WC	RK ORDER CHANGE	ES				
DATE	STEP	4 1	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				14-					
						i.			
Part No	-	PAR #:	Fault Cateç	Jory:	NCR: Yes	No) DQ	A: <u></u>	Date: _	010510
					QA: N	/C Close	d:	Date:	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
DATE	Description of NO	Description of NC		Corrective Action Section		Verification Approval			Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector
		# #							
Part No: _									
4	,	70							
	,	•							
		49 *							
÷									
					-				
		3.0							

NOTE: Date & initial all entries

Date: User: Thursday, 4/12/2007 8:46:31 AM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31737

Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 57.080/

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
							÷	
			3					

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	
			QA: N/C C	losed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	Annewal	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
			,			,		
						,		
÷								
,					1-1			
		(A)						
		4.	9					
						-		
				. •			-0-	3 4
				4.5			-	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31737
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments ·
1.20	+/-0.030	1,203"	1.00			
Ø0.510	+/-0.010	0,509"				
0.125	+/-0.010	130"				
2.44	+/-0.030	2.440"				
0.65	+/-0.030	,654"				
0.50	+/-0.030	503"				
19		, , ,				
00				,		
	1		,			4
				_	w.	

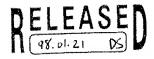
Measured by: 5.	Audited by:	ir	Prototype Approval:	N/A
Date: 07/04/26	Date:	07/04/26	Date:	N/A

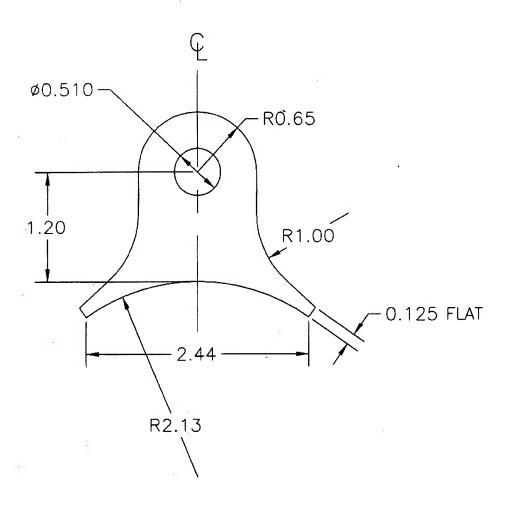
A 04 00 40 Noveleans D/O D005 044 044 0 D01 0404 044	Rev	Date	Change		Revised by	Approxed
A 04.08.12 New Issue P/O D205-641-011 & DSI 9161-011 KJ/JLM	Α	04.08.12	New Issue	P/O D205-641-011 & DSI 9161-011	KJ/JLM	





DESIG	nox	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECK	(ED_	APPROVED	DRAWING NO. R	EV. D
	LE	800	D2591 SHEET 1	OF 1
DATE	· · · · · · · · · · · · · · · · · · ·		TITLE	SCALE
98.0	1.21		GHW LUG	1:1
Α		96:09:16	NEW ISSUE	
В		97:06:17	RE-DESIGN TO FLAT BOTTOM	
С		97.12.12	RE-DESIGN TO RADIUS BOTTOM	
n		98.01.21	0.125 FLAT WAS 0.067 FLAT	-





0.063

BREAK_ALL SHARP CORNERS 0.010-TO 0.020 MATERIAL: ASTM A36 STEEL 0.50 THICK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE TRATEBOOPY
PART IS SYMMETRIC ABOUT CENTER-LINE SUBJECT TO AMENDMENT

ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING

WITHOUT NOTICE

WORK ORDER